

ABSTRACT

In a molding machine, foundry sand thrown into a molding space defined by a pattern plate and flask members is compressed in two steps. Namely, in the first step a lower subsidiary flask is stationary while in the second step the flask is movable. The pattern carrier molding machine comprises a molding base, flask-setting cylinders, a lift-support frame, and a segment-squeeze sand hopper. The auxiliary flask 62 of the compact pattern-plate carrier is installed movably up and down through a plurality of upward oil cylinders 63,63 that are expanded/contracted via special oil cylinders 64,65 operated by outside cylinders 68,69.